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IS 860 (1987): Handloom Cotton Sponge Cloth, Grey, Striped or Checked [TXD 8: Handloom and Khadi]



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Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”

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Indian Standard
SPECIFICATION FOR
HANDLOOM COTTON SPONGE CLOTH,
GREY, STRIPED OR CHECKED

(*First Revision*)

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BUREAU OF INDIAN STANDARDS
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NEW DELHI 110002

Indian Standard

SPECIFICATION FOR HANDLOOM COTTON SPONGE CLOTH, GREY, STRIPED OR CHECKED (*First Revision*)

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(*Continued on page 2*)

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(Continued from page 1)

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(Continued on page 8)

Indian Standard

SPECIFICATION FOR HANDLOOM COTTON SPONGE CLOTH, GREY, STRIPED OR CHECKED (*First Revision*)

0. FOREWORD

0.1 This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards on 11 May 1987, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

0.2 This standard, first published in 1956, has been revised in order to make it up-to-date in respect of the following changes:

- a) Yarn conforming to IS : 171-1985* has been recommended;
- b) Clauses on inspection, marking and packing have been included; and
- c) Latest versions of Indian Standards on test methods have been specified.

0.3 For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test, shall be rounded off in accordance with IS : 2-1960†. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

1. SCOPE

1.1 This standard prescribes the constructional particulars and other requirements of three varieties of handloom cotton sponge cloth, grey, striped or checked.

*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

†Rules for rounding off numerical values (*revised*).

1.2 This standard does not specify the general appearance, lustre, feel, finish or colour and their combination in striped or checked cloth.

2. MANUFACTURE

2.1 Yarn — The cotton yarn used in the manufacture of cloth shall conform to the requirements of IS : 171-1985*.

2.1.1 The warp yarn shall not be sized before weaving.

2.2 Cloth — Each cut end of the sponge cloth shall be hemmed to a depth of not less than 1 cm, the raw edges having a turn in of 10 mm before the hem is formed. Cotton sewing thread conforming to variety number 31 of IS : 1720-1978† shall be used in hemming and number of stitches shall be at least 40 per decimetre.

3. REQUIREMENTS

3.1 The cloth shall conform to the constructional requirements and other characteristics as given in Tables 1 and 2.

3.2 If in order to illustrate or specify the indeterminable characteristics, such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

3.2.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

4. INSPECTION

4.1 The cloth when visually inspected should be reasonably free from the following defects:

- a) Weft crack or more than two missing picks across the width;
- b) Prominently noticeable weft bar due to the difference in raw material, count, twist, lustre, colour, shade, etc;
- c) More than two adjacent ends running parallel, broken or missing and extending beyond 15 cm;
- d) Prominent selvage defects;
- e) Noticeable warp or weft float;
- f) Noticeable hole, cut or tear up to 3 mm in size;

*Specification for cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*).

†Specification for cotton sewing threads (*second revision*).

**TABLE 1 CONSTRUCTIONAL PARTICULARS OF HANDLOOM COTTON SPONGE CLOTH, GREY,
STRIPED OR CHECKED**

(Clause 3.1)

VARIETY No.	COUNT OF YARN (APPROX) (For Guidance Only)		ENDS	PICKS	WEIGHT	LENGTH	WIDTH	WEAVE
	Warp	Weft						
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)
	tex (Cotton Count)	tex (Cotton Count)	per dm	per dm	g/m ²			
1.	295 tex (or 2 ^s)	295 tex (or 2 ^s)	50	50	315			2/2 twill
2.	60 tex × 2 (or 10 ^s /2)	394 tex (or 1·5 ^s)	50	70	390	As agreed, see NOTE 1		2/2 twill
3.	30 tex × 2 (or 20 ^s /2)	148 tex (or 4 ^s)	40	30 (double)	270			One and one leno
Tolerance, percent	—	—	± 5	± 5	± 5	— 2	— 2	—
Method of test	—	—	IS : 1963-1981*		IS : 1964- 1970†	IS : 1954-1969‡		Visual

NOTE 1 — The usual width and corresponding length of sponge cloth are given below:

Width, cm

18
18
21

Length, cm

18
21
21

*Methods for determination of threads per unit length in woven fabrics (*second revision*).

†Methods for determination of weight per square metres and weight per linear metre of fabrics (*first revision*).

‡Methods for determination of length and width of fabrics (*first revision*).

**TABLE 2 REQUIREMENTS OF HANDLOOM COTTON SPONGE CLOTH,
GREY, STRIPED OR CHECKED**

(Clause 3.1)

SL No.	CHARACTERISTIC	REQUIREMENT	METHOD OF TEST
i)	Colour fastness (for striped or checked cloth only)		
a)	Light	4 or better	IS : 686-1985* or IS : 2454-1985†
b)	Washing : Test 4		IS : 765-1979‡
i)	Change in colour	4 or better	
ii)	Staining on cotton	4 or better	
ii)	Scouring loss, percent, <i>Max</i>	5	IS : 1383-1977§ (mild method)

*Method for determination of colour fastness of textile materials to daylight
(*first revision*).

†Method for determination of colour fastness of textile materials to artificial
light (xenon lamp) (*first revision*).

‡Method for determination of colour fastness of textile materials to washing:
Test 4 (*second revision*).

§Method for determination of scouring loss in grey and finished cotton textile
materials (*first revision*).

- g) Noticeable oil or other stains;
- h) Smash rupturing the texture of the fabric; and
- j) Prominently noticeable dyeing defects (bars, streaks and patches, etc).

4.1.1 A reference may be made to IS : 4125-1967* for details of these defects.

5. MARKING

5.1 The cloth shall be suitably marked or labelled with the following information:

- a) Name of the material, and variety number;
- b) Manufacturer's name, initials or trade-mark;
- c) Month and year of manufacture; and
- d) Length and width of piece.

*Glossary of terms pertaining to defects in fabrics.

5.1.1 The cloth may also be marked with the Standard Mark.

NOTE — The use of the Standard Mark is governed by the provisions of the Bureau of Indian Standards Act, 1986 and the Rules and Regulations made thereunder. The Standard Mark on products covered by an Indian Standard conveys the assurance that they have been produced to comply with the requirements of that standard under a well defined system of inspection, testing and quality control which is devised and supervised by BIS and operated by the producer. Standard marked products are also continuously checked by BIS for conformity to that standard as a further safeguard. Details of conditions under which a licence for the use of the Standard Mark may be granted to manufacturers or producers, may be obtained from the Bureau of Indian Standards.

6. PACKING

6.1 Unless otherwise agreed upon by the buyer and the seller, the cloth shall preferably be packed in bales or cases in conformity with the procedure laid down either in IS : 1347-1972* or IS : 293-1980†.

7. SAMPLING

7.1 The scale of sampling and criteria for conformity as given in IS : 3919-1966‡ shall be followed in respect of physical characteristics, namely, ends and picks, weight, length, width, and weave.

7.2 The scale of sampling and criteria for conformity as given in IS : 5463-1969§ shall be followed in respect of the chemical requirements of colour fastness and scouring loss.

*Code for inland packing of cotton cloth and yarn (*first revision*).

†Code for seaworthy packaging of cotton yarn and cloth (*third revision*).

‡Method for sampling cotton fabrics for determination of physical characteristics.

§Method for sampling of cotton fabrics for chemical tests.

(Continued from page 2)

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